

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009230**Date Inspected:** 26-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly-

This QA Inspector observed ZMPC Quality Control (QC) performing radiography of 2AW and 2AE Deck panel welds between panel point 13 and 14 for both segments. ZPMC appeared to be performing radiography in the locations designated by Caltrans QA.

Bay 10-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) welding of South Tower Lift 4 Skin Plate A to Skin Plate E corner joint weld SSTL4-4 B/L-3A. FCAW welding was performed at the 119 and 135 meter mark at areas where Submerged Arc Welding can not be performed after the lift is placed in support rings. ZPMC welders was identified as 040343 and 053869. ZPMC QC is identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-C-U2-F.

This QA Inspector observed the following work in progress: FCAW welding of South Tower Lift 3, 89 meter top diaphragm corner plate weld SSTL3-1- D/K-051 . ZPMC welder was identified as 040333. ZPMC QC is identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3212-B-U2a-2.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Bay 14-

This QA Inspector observed the following work in progress: FCAW of OBG Segment 10AW FL2 lower floor beam to FL3 floor beam splice weld SSD10-PP86-130. ZPMC welder was identified as 202122. ZPMC QC is identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-B-U2-F.

This QA Inspector observed the following work in progress: FCAW welding of OBG segment 10AW deck panel U rib to diaphragm plate welds DP100-001-081, 82, 83, 84, 85. ZPMC welder was identified as 062406. ZPMC QC is identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-2133 and WPS-B-T-2233-TC-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation occurred between QC and QA this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
